

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022859**Date Inspected:** 20-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: FB3178-167 [Edge Plate (EP) X4220D to Web Plate X4219A, complete joint penetration (CJP) weld, at Panel Point (PP) 118]. The welder is identified as 066398 and was observed welding in 1G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with Welding Procedure Specification (WPS): B-P-2211-TC-U4b-FCM-1.

Repair welding of weld joint nos: Seg3013P-042 [Edge Plate (EP) 3023A to Web Plate X4369B, CJP weld at PP118]. The welder is identified as 047864 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Welding

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Repair Report (WRR): 20736 Rev-0.

The SMAW process on weld joint no: FB3202-174 [Edge Plate (EP) X4149A to Web Plate X4176A, CJP weld, at PP120]. The welder is identified as 066398 and was observed welding in 1G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-P-2211-TC-U4b-FCM-1.

The SMAW process on weld joint no: FB3202-175 (EPX4149A to EP4149A, CJP weld, at PP120). The welder is identified as 066398 and was observed welding in 1G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-P-2211-TC-U4b-FCM-1.

OBG Seg13CW:

Repair welding of weld joint nos: DP3148-001-253 [FB diaphragm (X4090C) to longitudinal stiffener plate (X4128C), CJP weld at PP124.5]. The welder is identified as 067588 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Shi Li. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): 2931 Rev-0.

Repair welding of weld joint nos: Seg3015-001 [Deck Panel (DP) splice weld (for DP3148A and DP3149A), CJP weld at]. The welder is identified as 067764 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Shi Li. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): 20631 Rev-0.

Grillage assembly on Seg 13AW:

ZPMC personnel performing cope hole profile grinding after completion of repair welding. Repair welding (as per CWR: 2927 Rev-0) of the welds; after MT, was observed to be done. See attached photo for further details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
